

Date: Monday, 27/04/2009 12:50:36 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : JACK
Job Number : 47515	
Estimate Number : 10527	
P.O. Number :	Part Number : D33361
This Issue : 27/04/2009 S.O. No. :	Drawing Number : D3336 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 45181	Material :
Written By :	Due Date : 10/05/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JUL 09.04.27</u>	
Comment : Est. A05.01.13 New issue KJ/JLM	
Est. A05.12.13 Added paint EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 8671CX09/04/28

For D3336-1 Jack P/N: 76508

Possible Supplier: Auto PartsProduct Specification sheet is required

2.0	76508	JACK
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
JACK

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive and Inspect for transit damage

Ensure Product Specification sheet is attached

P 9/4/29 (S)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Drill base of jack using DT8761 as per Dwg D3336

2-Check ram length, then tack weld as per Dwg D3336

3-Drill and Tap ram as per Dwg D3336 N/A ECSP 09.05.05Qty 1 Hc-12 1/4"-20 UNC X 1" LONG HEX BOLT, SPAN -> B/6529 (6X)W see attached

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 27/04/2009 12:50:36 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK

Job Number: 47515

Part Number: D33361

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Paint base cuts to match color per dwg D3336

TOUCH - O P PAINT

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

JH 09-05-06 (X6)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/06 (16)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

SAD 09-05-06 (6x)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/07 JH

Job Completion



mf
09-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

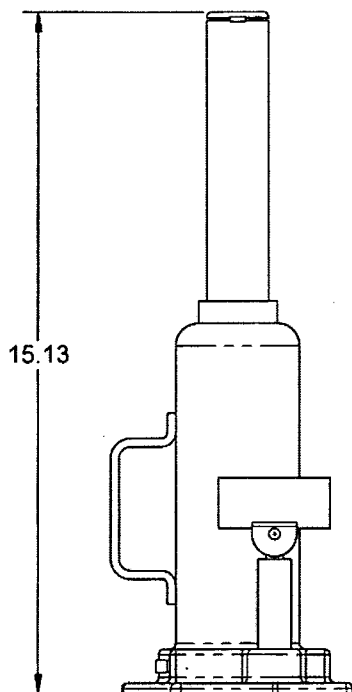
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3336	REV. A SHEET 1 OF 1
DATE 04.12.16		TITLE JACK	SCALE 1:2
A	04.12.16	NEW ISSUE	



DETAIL A: SIDE VIEW
SCALE 1:4

DRILL 0.312 PER
TEMPLATE DT8761
(2 PLACES)

COUNTER BORE $\varnothing 0.38$
IF NECESSARY FOR
CLEARANCE OF BOLT
HEAD (2 PLACES)

DRILL 0.201 x 1.00 DEEP
AND TAP 1/4-20 x 0.75 DEEP
AT CENTER OF CAP.

WELD CAP WITH SHAFT
WITH 0.375 LONG
TACKS (2 PLACES)
AROUND PERIMETER

RELEASED
[Signature]
05/02/09

TRIM EDGES AS PER
TEMPLATE DT8761
AND PAINT CUTS TO
MATCH COLOR.

D3336-1

NOTES:

- 1) MATERIAL: 8 TONS JACK. POSSIBLE SUPPLIER: AUTOPARTS
MODEL NUMBER 76508
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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**AUTO PARTS • PIÈCES D'AUTO
TRUCK PARTS • PIÈCES DE CAMION
ENGINE-MARINE • MOTEUR-MARINE
PERFORMANCE PARTS • PIÈCES DE PERFORMANCE
TIRES • PNEUS**



Past due accounts bear 2% interest per month (24% per annum). If this account is placed with a 3rd party collection, an administrative cost of 25% will be added. All exchanges and refund claims must be accompanied by this invoice. Electrical parts not returnable. All parts returned are subject to 20% handling charge. All merchandise sold on this invoice remains the vendor's property until this invoice is paid in full.

Aucun remboursement sans cette facture. Net 30 jours, 2% de frais d'intérêt par mois (24% par année) sur compte en souffrance. 20% de frais de manutention sur toute marchandise retournée. Clause pénale une indemnité de 25% sera chargée sur compte sujet à des procédures légales. Les marchandises mentionnées sur cette facture demeurent la propriété du vendeur tant qu'elles ne seront pas entièrement payées. Pièces électriques non-retournable.

TERMS: Payment due on 10th day of the following month.

SIGNATURE

1000 RUE LANDSDOWNE
TEL: (613)632-1191

HAWKESBURY, ON K6A 1H7
FAX: (613)632-2350

GST / TPS
10035 3366 RT0001

TVQ
1016330716 TQ0001

Promotion cardans AC Delco-Cartes cadeaux Tim Hortons du 15 janvier au 15 avril 2009. recevez \$5 cartes cadeaux TIM a chaque achat d'un cardan AC DELCO.

113336 (613)632-5200		113336		DATE: 4/29/09 13:22 111 MLP					
S V DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY ON K6A 1K7		EXPEDITEUR *** SAME ***		0008671					
ORD / COM	SHIP / EXP	CODE	PART No / PIÈCES	DESCRIPTION	LIST EACH / CHACUN	COST / COÛTANT	EXTENSION		
6	6	G2S>	NOR76508 ✓ g2s= in189322	8 ton axle jack		154.00	924.00		
	6	***	SHIP VIA	PIECES/CORE TOT REGULAR Merci	0.00		0.00		
INVOICE No / FACTURE 11941199		TYPE / SORTIE INVOICE		TOTAL 924.00	DISC / ESC 0.00	FRT / TRANS 0.00	GST / TPS 46.20	PST / TVQ 0.00	AMT to PAY / A PAYER 970.20

VERSUS BUSINESS FORMS (CORNWALL) (613) 936-1852

000000

DART

Purchase Order

Date Apr 28, 2009	Page 1
Purchase Order Number PO00008671	

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

REVISED

Vendor Address:

Auto Parts Extra
1000 rue Lansdowne
Hawkesbury, ON K6A 1H7
Canada
Phone (613) 632-1191
Fax (613) 632-2350

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-AUT001	Apr 28, 2009	N30	yours	May 04, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
6.0000	76508	JACK Comments: AS PER DWG D3336 REV. A B47515 AUTO PART P/N: 76508	04/05/2009	No	154.000000	Each	924.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Comments:

Tax Summary:
GST 46.20
GSTME 0.00
GSTND 0.00

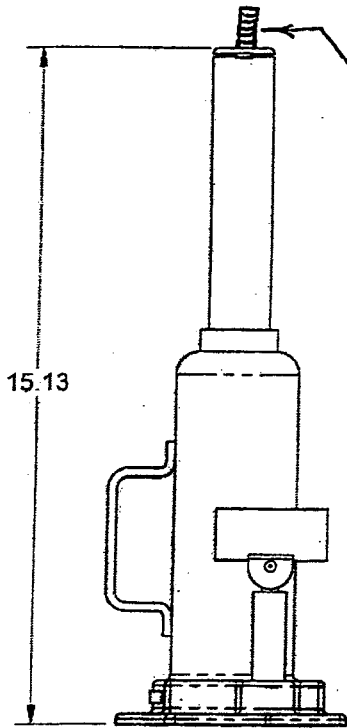
Less: included tax	0.00
Subtotal	924.00
Total tax	46.20
Total purchase order in CAD Dollars	970.20

Entered By: *CL* CLAVOIE

Approved By: *W*

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3336	REV. A SHEET 1 OF 1
DATE 04.12.16		TITLE JACK	SCALE 1:2
A	04.12.16	NEW ISSUE	



DETAIL A: SIDE VIEW
SCALE 1:4

CUT BOLT AND WELD
ON JACK
Hc 12

1/4-20 BOLT
1"

Cpl 09-04-29

DRILL 0.201 x 1.00 DEEP
AND TAP 1/4-20 x 0.75 DEEP
AT CENTER OF CAP.

WELD CAP WITH SHAFT
WITH 0.375 LONG
TACKS (2 PLACES)
AROUND PERIMETER

RELEASED
[Signature]
05/02/09

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L Lacelle

From: Roberto Fuentes [rfuentes@dartaero.com]
Sent: January 7, 2009 12:27 PM
To: 'L Lacelle'
Cc: 'Mike Petsche'; 'David Shepherd'; bbeckett@dartaero.com
Subject: RE: Hydraulic grd handling

It is ok with me, if that produce scraps the way it is now, also I check with the guys here at Eagle and said it is fine with them. Only concern with me is make sure the bolt is weld straight with shaft and have good solid weld between cap of the jack and bolt and the thread shown after nut be max. 1/4" and may be add a lock washer. This will required to update assembly drawing.

Roberto

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Wednesday, January 07, 2009 7:44 AM
To: 'Roberto Fuentes'
Cc: 'Mike Petsche'; 'David Shepherd'; bbeckett@dartaero.com
Subject: RE: Hydraulic grd handling

Forgot to include attachment...sorry

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: January 7, 2009 9:42 AM
To: 'Roberto Fuentes'
Cc: 'Mike Petsche'; 'David Shepherd'; 'bbeckett@dartaero.com'
Subject: Hydraulic grd handling

Hi all,
Carl had a grwat idea, to save time and parts, please see attached.
We sometimes break the cap part of the jack, by cutting off the head of the bolt and welding it on, it would take less time and make less scrap...
Let me know what you's think.

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd